

Date: Tuesday, 11/29/2005 2:49:49 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GUIDE  
 Job Number : 25012  
 Estimate Number : 11073  
 P.O. Number : N/A  
 This Issue : 11/29/2005 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : MACHINED PARTS  
 Previous Run : N/A  
 Written By : SEE ABOVE DATE & USER  
 Checked & Approved By : SEE ABOVE DATE & USER  
 Comment : Created By Auto Work Order!!\* Late - Some of the material cannot be made in time.

Part Number : D31373  
 Drawing Number : D3137 REV D  
 Project Number : N/A  
 Drawing Revision : D  
 Material : N/A  
 Due Date : 11/29/2005 Qty: 30 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MDELRLNB075X1250 Delrin Bar



Comment: Qty.: 0.0831 f(s)/Unit Total : 1.6611 f(s)

Mat:Black Delrin bar 1.250" x .750"

( ref DART spec. M-DELRIN-B )

Batch: M 14535

Tools:

J.G. 05/12/16 2031

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut Blanks.Blank size: 1.250" x .750" x .950" long

Tools:

J.G. 05/12/16 2031

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA242 & Dwg D3137

2-Deburr

Tools:

J.L 06-02-10 31

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Tools:

J.L 06-02-10 21

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Tuesday, 11/29/2005 2:49:49 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 25012

Part Number: D31373

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Tools:

86 06.02.10

31

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

Tools:

14 06.02.10

31

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Tools:

DP 06.02.10 (31)

Job Completion



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



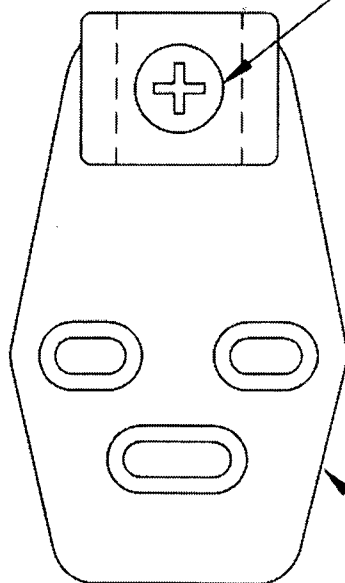
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|------------------|---------------|---|------------------------|
| DESIGN<br>#      | DRAWN BY<br># | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>#     | APPROVED<br># | DRAWING NO.<br>D3137                              | REV. D<br>SHEET 1 OF 4 |
| DATE<br>04.11.03 |               | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:1           |
| A                | 02.04.17      | NEW ISSUE   |                        |
| B                | 03.01.16      | ADD RIDGES; ADD MAT'L PROP.                       |                        |
| C                | 03.08.15      | ADD -043  |                        |
| D                | 04.11.03      | RE-DESIGN D3137-5; CHANGE DIMS                    |                        |

RELEASED  
04.11.23 #

UNDER REVIEW

05.08.29 #

D3137-041 } ONLY  
# D3137-1 }



MS24694-S101 SCREW  
D3137-5 WASHER  
D3137-3 GUIDE  
INSTALL ON SAME SIDE AS C'SINKS  
(OPPOSITE SIDE FROM RIDGES)

D3137-1 BRACKET (-041 SHOWN)  
OR  
D3137-7 BRACKET (-043 SIMILAR)

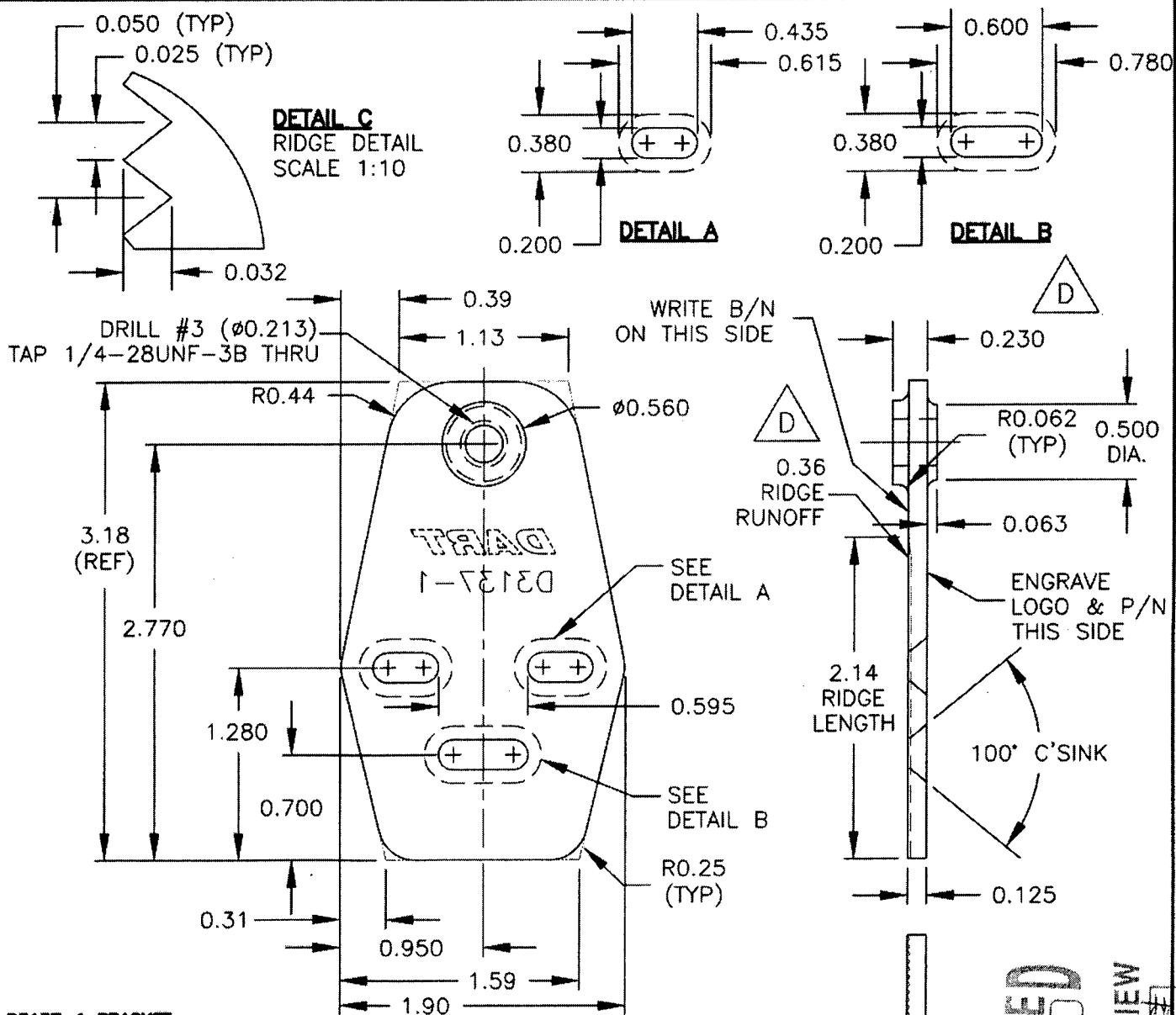
D3137-041 BRACKET ASSEMBLY (SHOWN)  
D3137-043 BRACKET ASSEMBLY (SIMILAR)

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**DART**

|                        |                           |  |                        |
|------------------------|---------------------------|--|------------------------|
| DESIGN<br>[Signature]  | DRAWN BY<br>[Signature]   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature]   | DRAWING NO.<br>D3137                                     | REV. D<br>SHEET 2 OF 4 |
| DATE<br>04.11.03       | TITLE<br>BRACKET ASSEMBLY |  | SCALE<br>1:1           |



- 1) REPLACES PREMIER P/N B30-23000-105/-106 BRACKETS
- 2) MATERIAL: 17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010  
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANET INK MARKER

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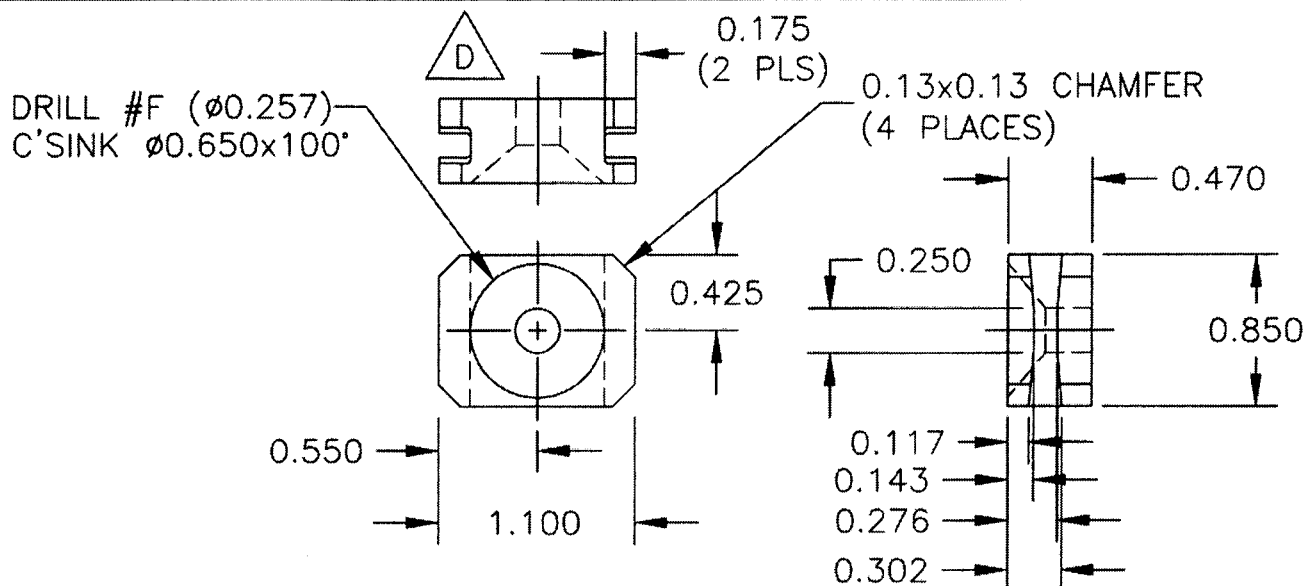
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RELEASED  
04.11.03UNDER REVIEW  
05.08.29D3137-041  
# D3137-1 ONLY





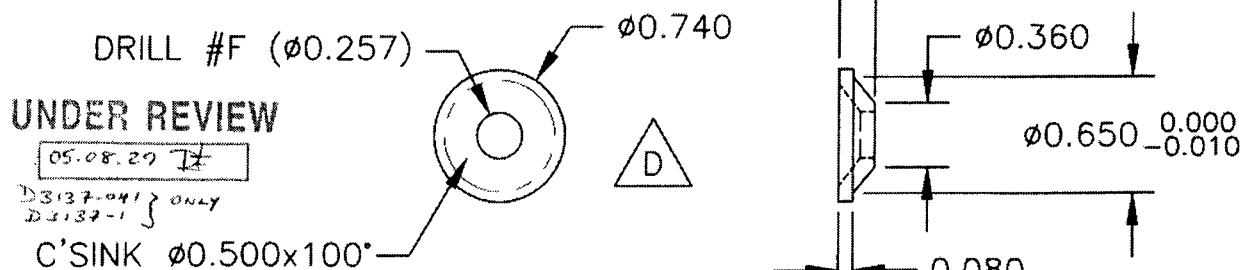
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| DESIGN<br>#      | DRAWN BY<br># | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>#     | APPROVED<br># | DRAWING NO.<br>D3137                              | REV. D<br>SHEET 3 OF 4 |
| DATE<br>04.11.03 |               | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>1:1           |



#### D3137-3 GUIDE

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015

RELEASED  
04.11.2004



#### D3137-5 WASHER

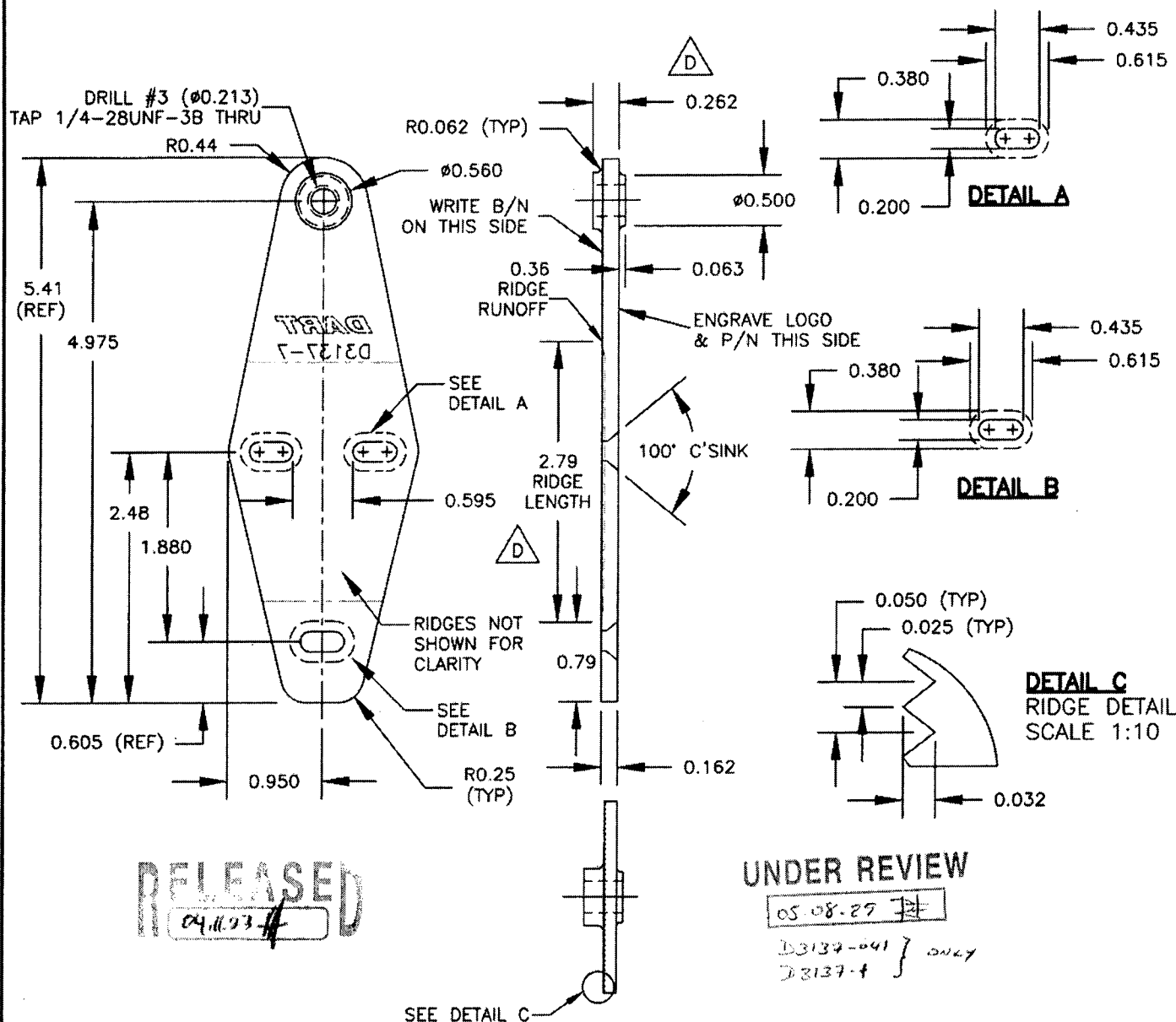
- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6R)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

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|                  |               |   |                        |
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| CHECKED<br>#     | APPROVED<br># | DRAWING NO.<br>D3137                              | REV. D<br>SHEET 4 OF 4 |
| DATE<br>04.11.03 |               | TITLE<br>BRACKET ASSEMBLY                         | SCALE<br>2:3           |

**D3137-7 BRACKET:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010  
WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
- 7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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